

Work Order ID 83228

83228

Page 1

April 16, 2012 8:45:46 AM

Item ID: D4017-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib
 Start Date: 4/16/12 Start Qty: 4.00 ***4*** 12x
 Required Date: 4/20/12 Req'd Qty: 4.00 ***4***
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: CL Date: 12/04/16 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4017	C

100 0.00
100
 Large Fab Memo 0.00
 Large Fab 1- Cut tube as per dwg D4017
 2- Deburr and remove identify marks

12x Ø P12.05.02

110 QC6- Inspect dimensions to drawing 0.00
110
 QC Memo 0.00
 Quality Control

(12x) Ø P12.05.02

120 Identify as per dwg & Stock Location: WA 0.00
120
 Packaging Memo 0.00
 Packaging

12x Ø P12.05.02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

April 16, 2012 8:45:46 AM

Item ID: D4017-9

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib

Start Date: 4/16/12 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 4/20/12 **Req'd Qty:** 4.00 ***4***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

11/2-08-2

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Picklist Print

April 16, 2012 8:45:45 AM

Page 1

Work Order ID: 83228

Parent Item: D4017-9

Parent Item Name: Rib

Start Date: 4/16/12

Required Date: 4/20/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as per dwg RevA DD
10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP
Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 11.01.17 chg qc5 to 6 DD
verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049 Square Tubing		Purchased	No			100	f	324.1318	2.28166	9.6069895		4/12/12 05:02	

Location

Loc Qty

Loc Code

MAT034

324.1317993

118460

0.00001534

121328

324.131784

M121565 → 28.821

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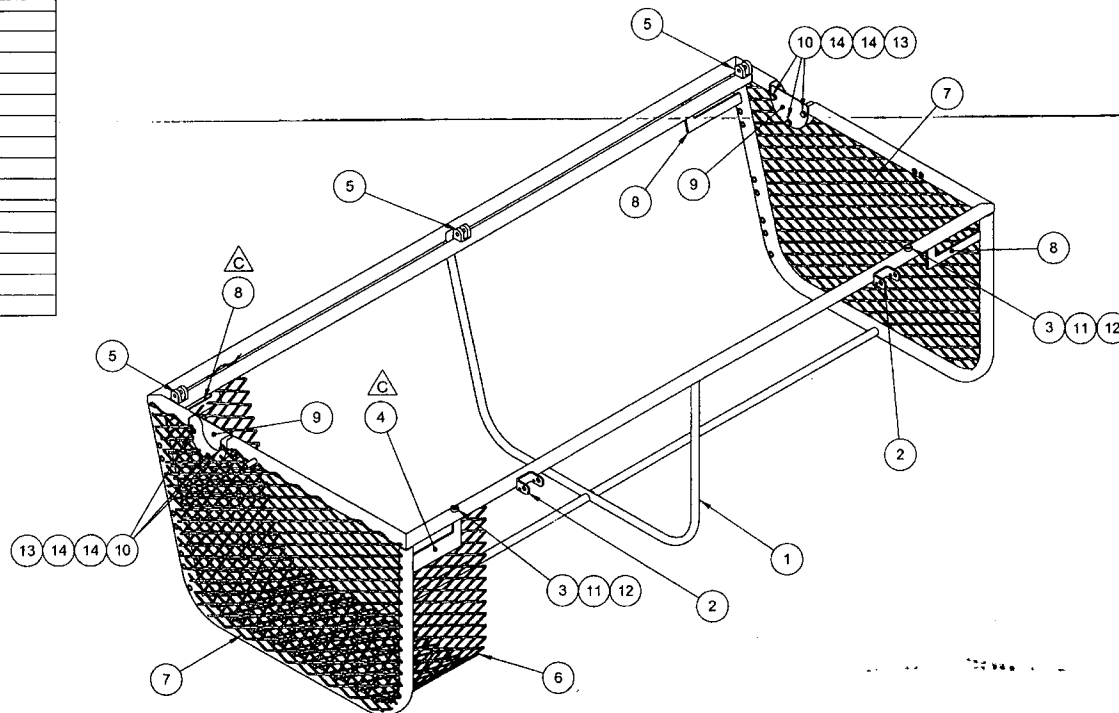
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ITEM	QTY .041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20800AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596
RELEASED
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

C212104/116
WID: 83228

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	2		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	3.13.11	D4017	SHEET 1 OF 5
APPROVED	10/10	TITLE	SCALE
DE APPR.	10/10	SHORT BASKET BASE ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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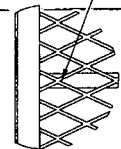
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION



DETAIL C D5-2

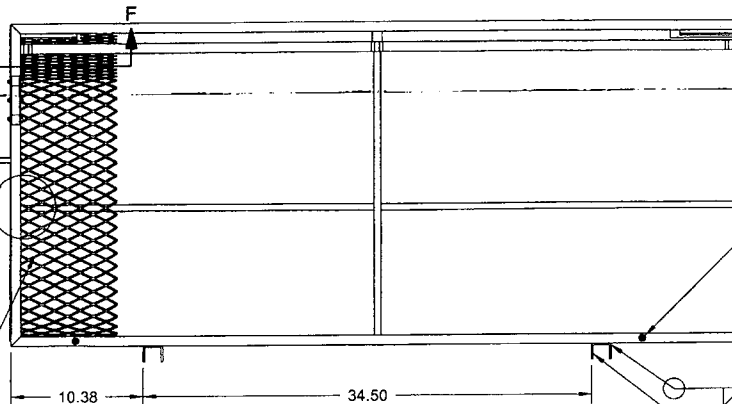
SECTION F-F
TYPICAL FOR ALL
HANDLE PLATES

D5-2

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

D4021-1
HANDLE PLATE

D6-2 F
C8-2
D4020-3
MESH

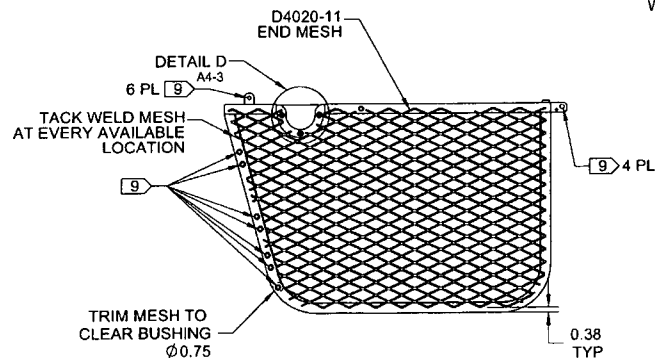


D4017-101
TUBULAR ASSY

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL 8

D2581
MOUNTING BRACKET
2 PL

2 PL



D4020-11
END MESH

DETAIL D
A4-3
6 PL 9

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

9

9 4 PL

TRIM MESH TO
CLEAR BUSHING
Ø0.75

0.38
TYP

D3913-15
WIDE HANDLE PLATE

0.75
2 PL

A

27.94

D4016-1
HINGE HALF, BASE
3 PL

D4021-1
HANDLE PLATE
2 PL

3 PL

B2-3 B

D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-12 09

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D4017	REV. C
MFG. APPR.	JES		SHEET 2 OF 5
APPROVED	JW	TITLE	SCALE
DE APPR.	W	SHORT BASKET BASE ASSY (350) - NTS.	
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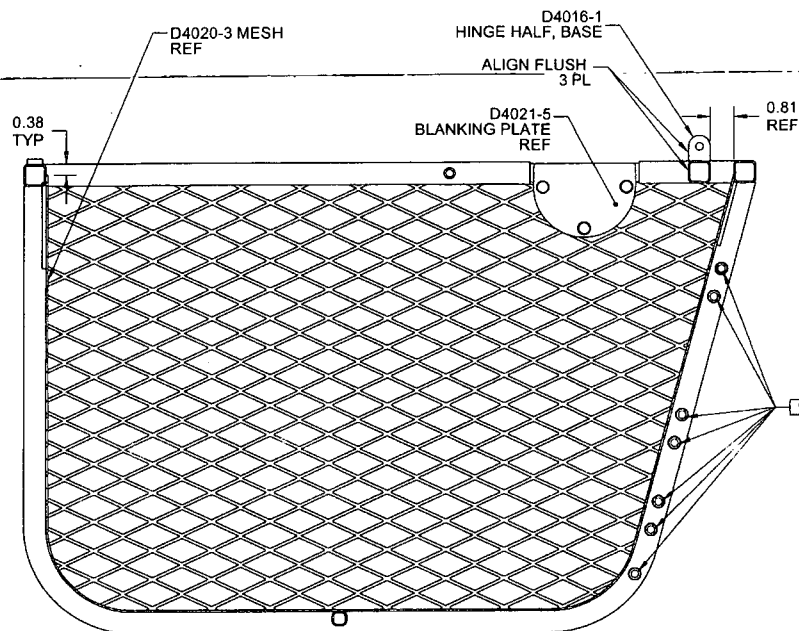
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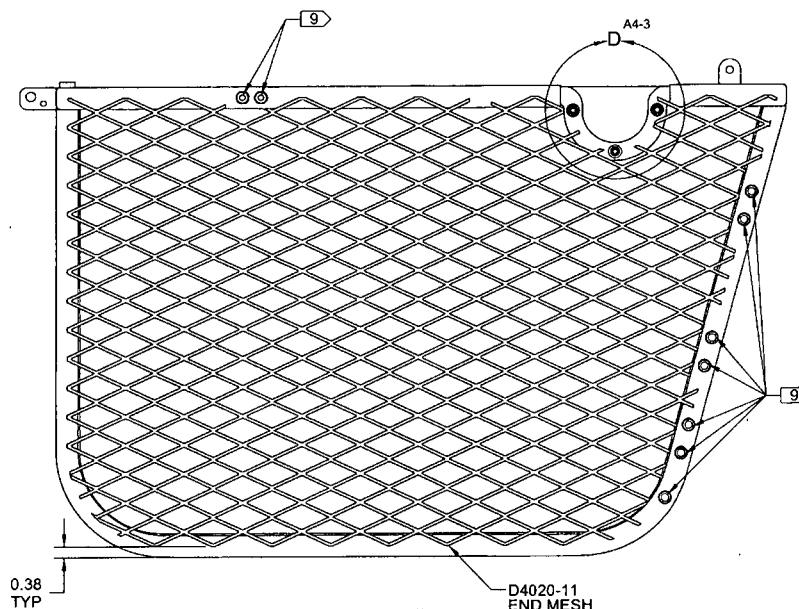
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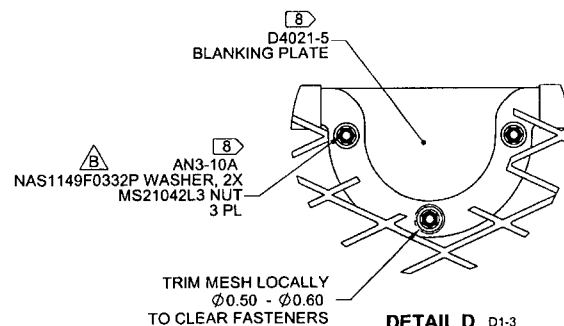
D



SECTION A-A A5-2



SECTION B-B A2-2



DETAIL D D1-3 B8-2

RELEASED
10.08.12 42

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	10	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JFS	DRAWING NO.	REV. C
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1

A

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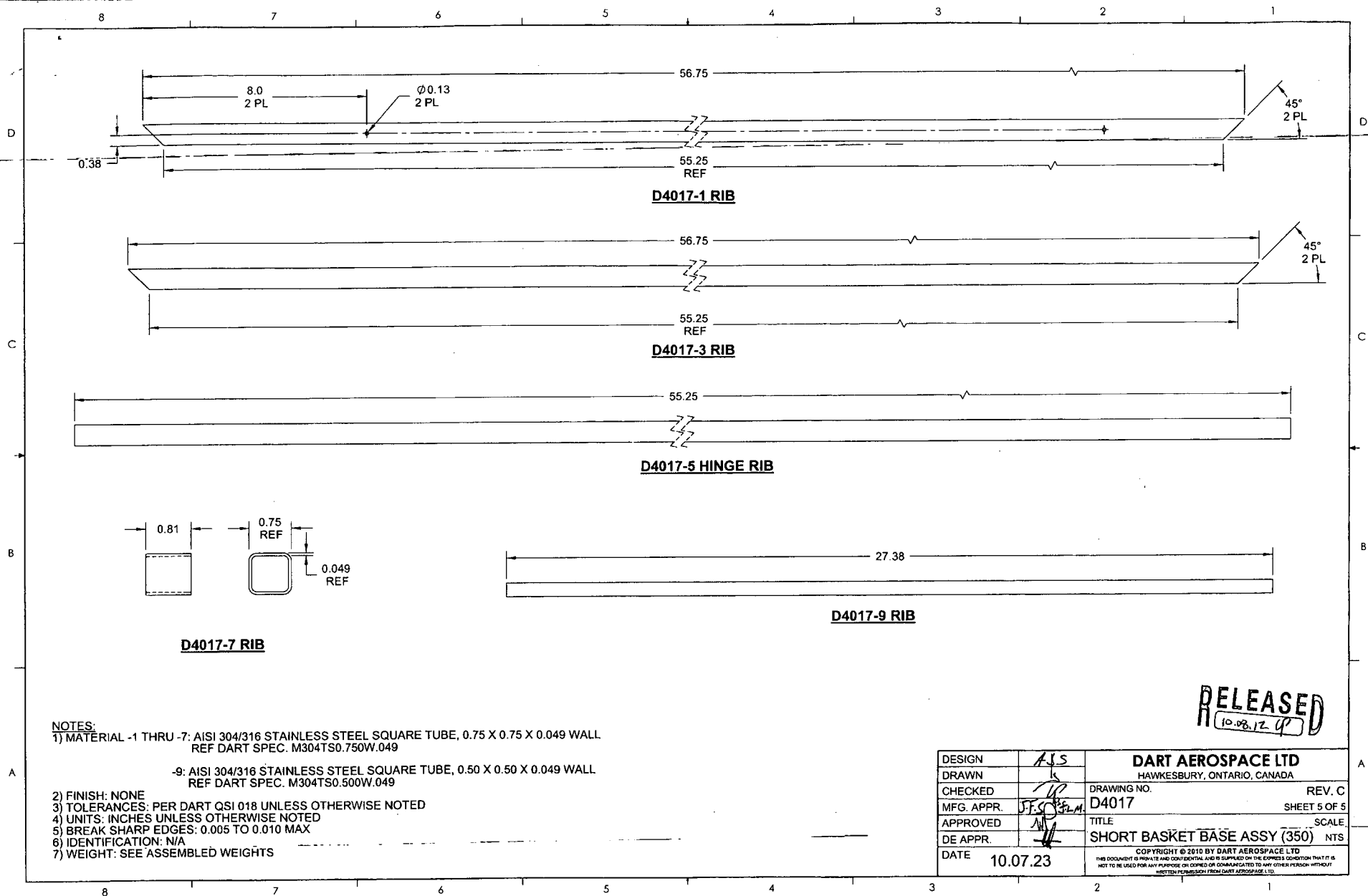
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